

SPUT

Date: Wednesday, 3/7/2007 3:36:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 31089		
Estimate Number	: 10364		
P.O. Number	: N/A	Part Number	: D3046041
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D3046 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 29749	Material	: N/A
Written By	:	Due Date	: 3/14/2007 Qty: 50 Um: Each
Checked & Approved By	: [Signature] 07.03.07		
Comment	: Est: A 01.08.27 New issue SM/EC est: B 06.11.30 Per revB, EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D30461	Lug Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3046-1	Lug Bracket
---	---------	-------------

B3324-1

07/10/25

(40x)

2.0	D30465	HOOK
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

LUG

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D3046-5 Lug

B31382

52/01/70

40x

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3046

8/07/10/25

40K

40	QC5	INSPECT WORK TO CURRENT STEP
----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

15 2/10/26 40

50 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-26 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:36:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31089

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 4929

Heat treat Ass'y as per Dwg D3046

(Heat treat ass'y to H900 hardened condition min 190 KSI)

Possible Supplier: Vac-aero

Certificate of conformity required

C207110129 (40)

7/11/29 40x SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

7/11/06 SP (40x)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure certificate of conformity comply to Dwg D3046

6 7/11/09 (40x)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M105914

M-6 07/11/12 (40x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 07-11-12 (40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 272A

overstock 07/11/12

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(40) 07/11/13

Job Completion



W 07/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

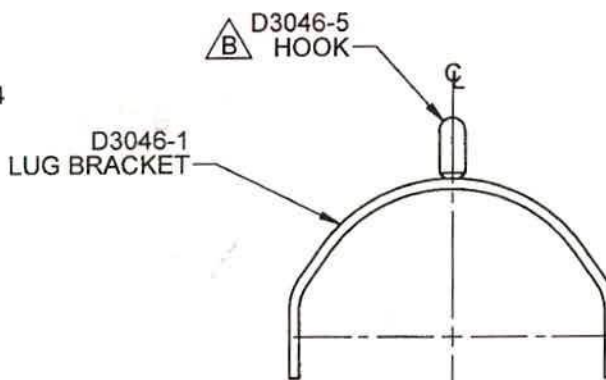
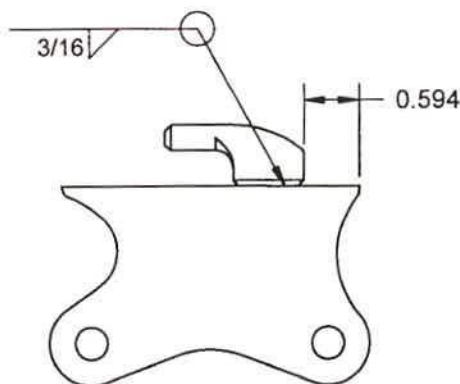
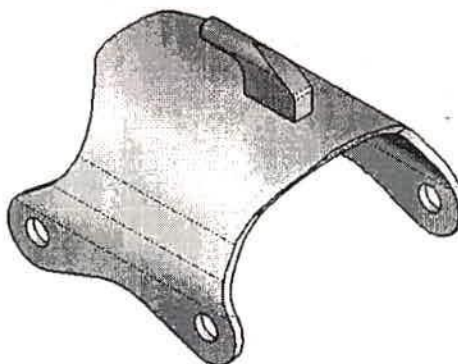
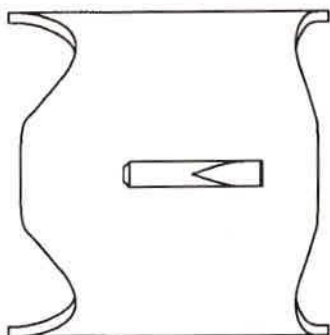
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY SCALE 1:2	
REV	DATE	DESCRIPTION	
A	01.08.23	NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED
06.11.13 #



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

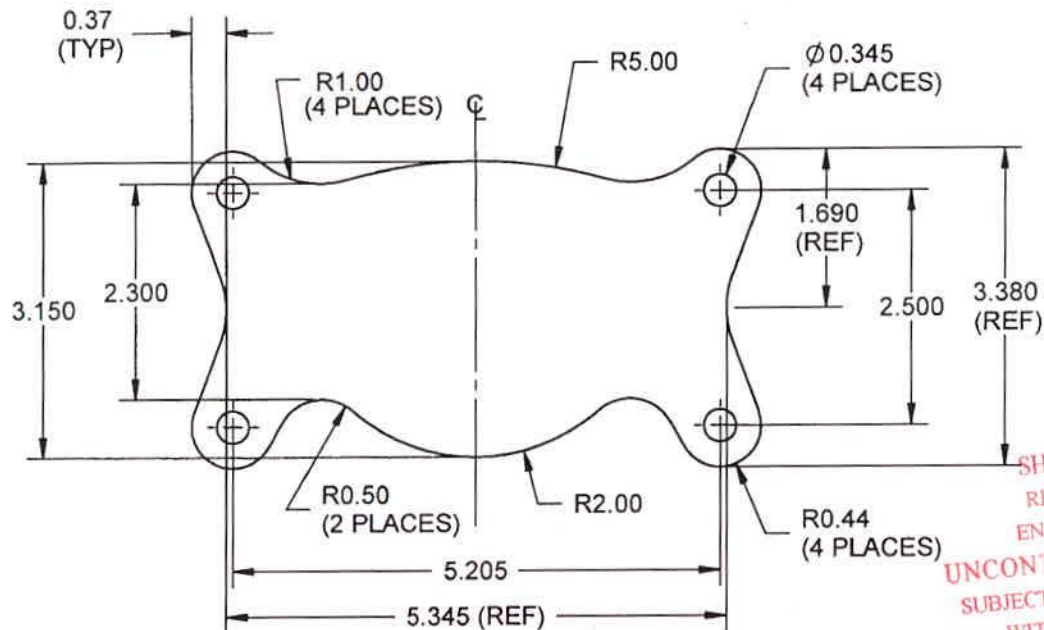
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31089

COPYRIGHT © 2001 BY DART AEROSPACE LTD

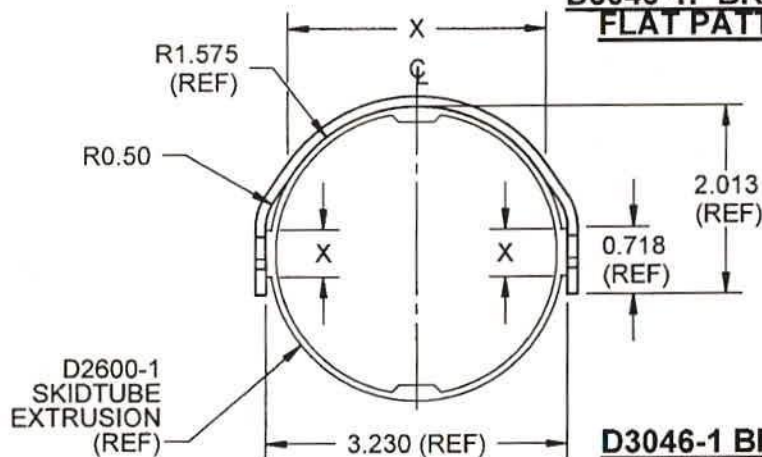
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

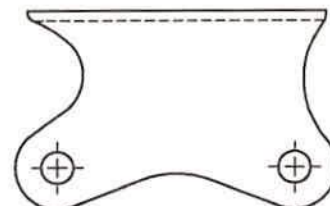
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



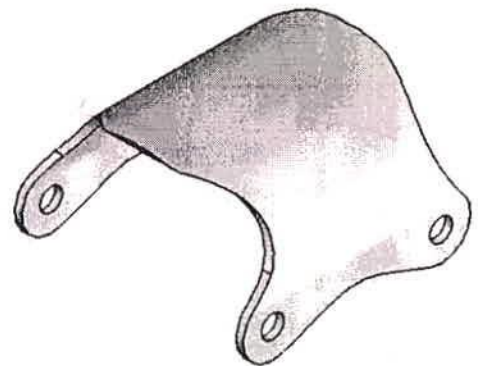
**D3046-1 BRACKET
BEND DETAIL**

**RELEASED**

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

**COPYRIGHT © 2001 BY DART AEROSPACE LTD**

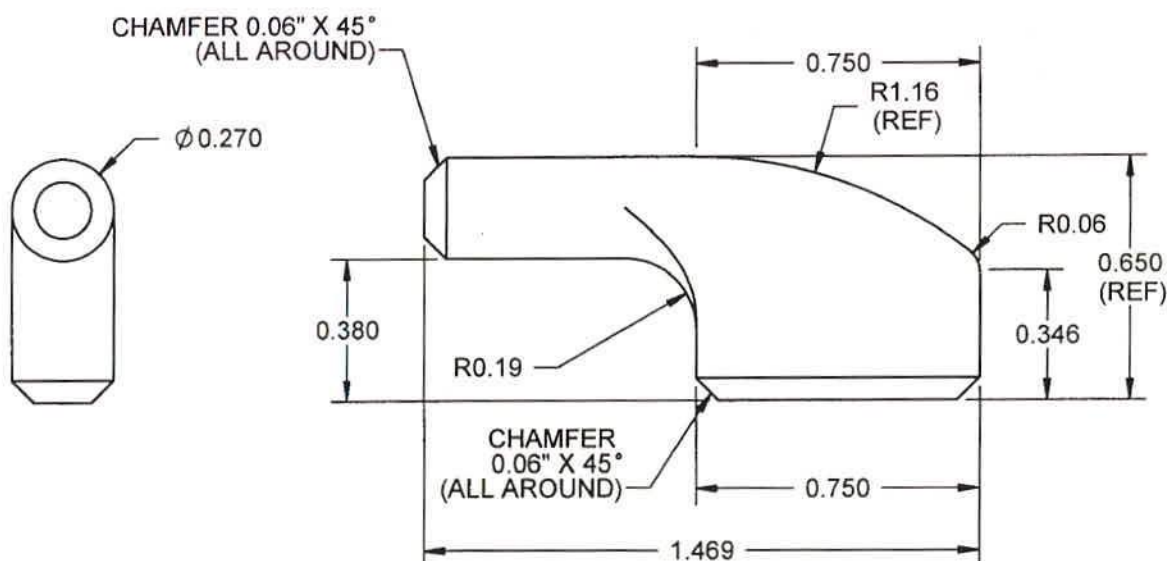
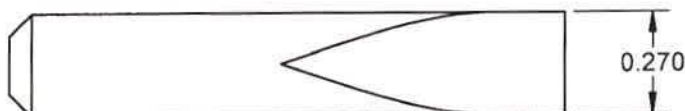
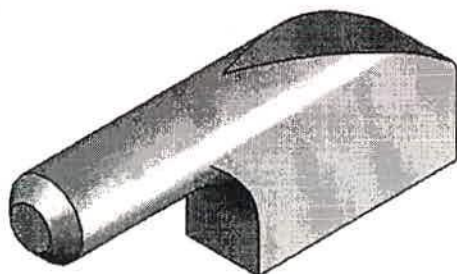
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 2:1

RELEASED

06.11.13

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643
(REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31089

COPYRIGHT © 2001 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 92441-1

11/05/2007

MM/DD/YYYY

PAGE: 1

☒ HEAD OFFICE
1571 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827 4171 FAX: (905) 827-7489

☐ 2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

☐ QUEBEC DIVISION
7450 RUE VERITE STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/05/2007		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
4929		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
----------	-------------	-----	------------	-------------	--------------

33046

-041 B31089

EA 40 40

Process Specifications:

Procedure: 3806

HEAT TREATED TO H900 PER AMS 2759-3D

(120 KSI MINIMUM)

100% HARDNESS TESTED PER ASTM E-18, HRC 40-47

MATERIAL: 17-4

100% HARDNESS TESTED

40 - pcs

42/43 HRC

JK



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Sandra Robinson
Authorized O.C. Inspector





VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 92441-1

11/05/2007

MM/DD/YYYY

PAGE: 1

☒ HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

☐ QUEBEC DIVISION
7450 RUE VERITE STREET, ST. LAURENT, QUEBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K5A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/05/2007		
CUSTOMER P/O No.	JOB No.	ORIGIN
4529		TERMS
		COD

LM	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
1	D3046 ✓	-041 B31089	EA	40	40	0
		Process Specifications: Procedure: 3806 HEAT TREATED TO H900 PER AMS 2759-3D (190 KSI MINIMUM) 100% HARDNESS TESTED PER ASTM E-18, HRC 40-47 MATERIAL: 17-4				
2	MC	MINIMUM CHARGE		1	1	0
		2/1/06 59				

claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.

